

Date: Thursday, 2/22/2007 2:57:23 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 30809	
Estimate Number : 10001	
P.O. Number : <i>N/A</i>	Part Number : D2213
This Issue : 2/22/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2213 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30107	Material : <i>N/A</i>
Written By : _____	Due Date : 3/20/2007 Qty: 160 Um: Each
Checked & Approved By : <i>07.02.23</i>	
Comment : Est Rev: C Turned In-House 05-10-17 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0750	6061-T6 Round Bar .750"
-----	--------------	-------------------------



*W 07.05.23*  
 Comment: Qty.: 1,1000 in(s)/Unit Total: 176.0000 in(s)

MATERIAL: 6061-T6 Round Bar .750"

(M6061T6R0750)

Batch: *M 103755**DSP 07/05/19*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA113 &amp; DWG D2213,

FOLIO REV: *B*DWG REV: *B*

2-DEBURR AS REQUIRED

*DSP 07/05/19* **(175)**

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DSP 07/05/19* **175**

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*BG 07-09.22* **175**

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FD* *07/05/22* **(175)**

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/05/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/22/2007 2:57:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 30809

Part Number: D2213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8F20

W

7/5/23

59

(175)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(175)

Comment: FINAL INSPECTION/W/O RELEASE

207/05/23

Job Completion



W 07/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

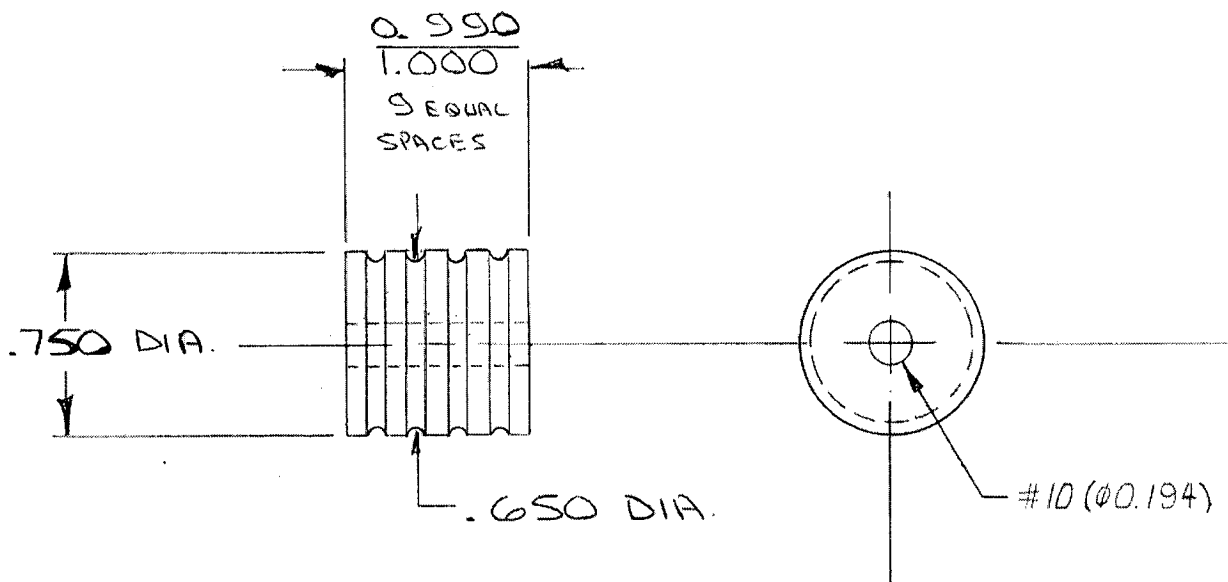
**NOTE:** Date & initial all entries







DRAWN BRADLEY 94.2.9		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.2.9		DRAWING NO. DZZ13	REV. B
STRESS		TITLE SPACER	
B	95:08:17	#10 HOLE ADDED	



MATERIAL

ALUMINUM ALLOY 2011-T3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30809